



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 73910

Monday, September 19, 2011 10:06:48 AM



Page 2

Item ID: D3822-2KGY

Accept



Setup Start



Revision ID:

Stop



Item Name: Vertical Tunnel, RH-Grey

Start Date: 9/19/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/23/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up  
2-Pre-heat Tool to required temp.  
3-Thermoform as per Dwg and Folio #FTA026 using tool DT9074  
Dwg Rev: C  
Folio Rev: B

x2

u/12/21

120

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

x2

u/12/21

130

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

u/12/23

Q

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**Work Order ID 73910**

Monday, September 19, 2011 10:06:48 AM



Page 3

Item ID: D3822-2KGY

Accept



Setup Start



Revision ID:

Stop



Item Name: Vertical Tunnel, RH-Grey

Start Date: 9/19/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/23/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

x2

DH

11/12/22

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Complete FAI document

x2

DH

11/12/22

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5/11/23

R2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 73910**

Monday, September 19, 2011 10:06:48 AM



Page 4

Item ID: D3822-2KGY

Accept



Setup Start



Revision ID:

Stop



Item Name: Vertical Tunnel, RH-Grey

Start Date: 9/19/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/23/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

Identify as per dwg &amp; Stock Location: 152

0.00



Packaging

Memo

0.00

Packaging

11/12/29 2/2

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 12/01/02

11/12/29  
2/2

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



# Picklist Print

Monday, September 19, 2011 10:06:44 AM

Page 1

Work Order ID: 73910



Parent Item: D3822-2KGY



Parent Item Name: Vertical Tunnel, RH-Grey

Start Date: 9/19/2011

Required Date: 9/23/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC v  
Add Step 105 Dry Material 10/04/21 DL

IPP Rev. B.

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 52068		Purchased	No			100	sf	436.3796	7.8	15.60780			



Kydex steel grey

Location

therm

Loc Qty

436.3796282

436.379628

Loc Code

~~111807~~

119476

15.60780 sg 04

DL  
11/12/21

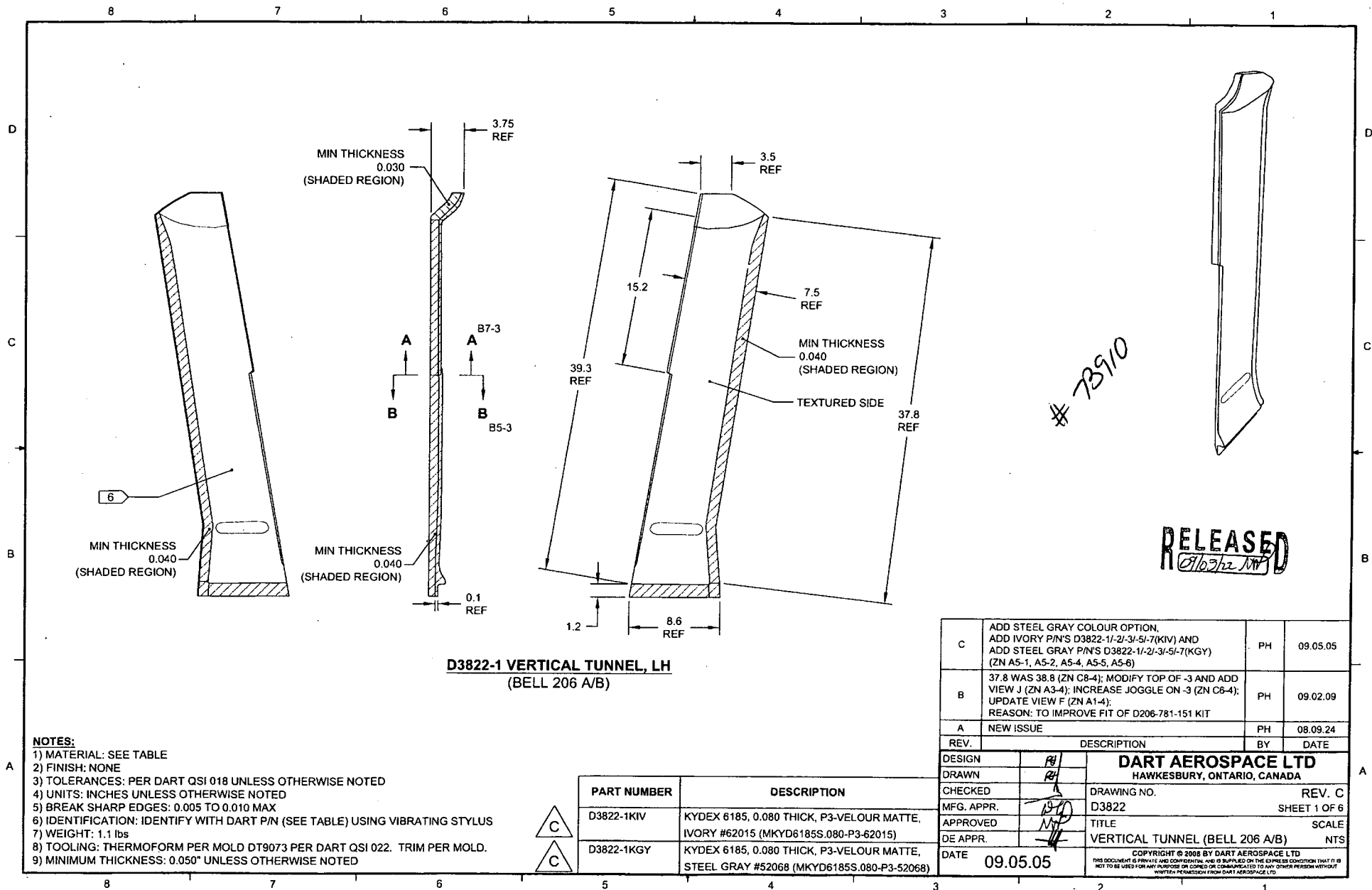
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



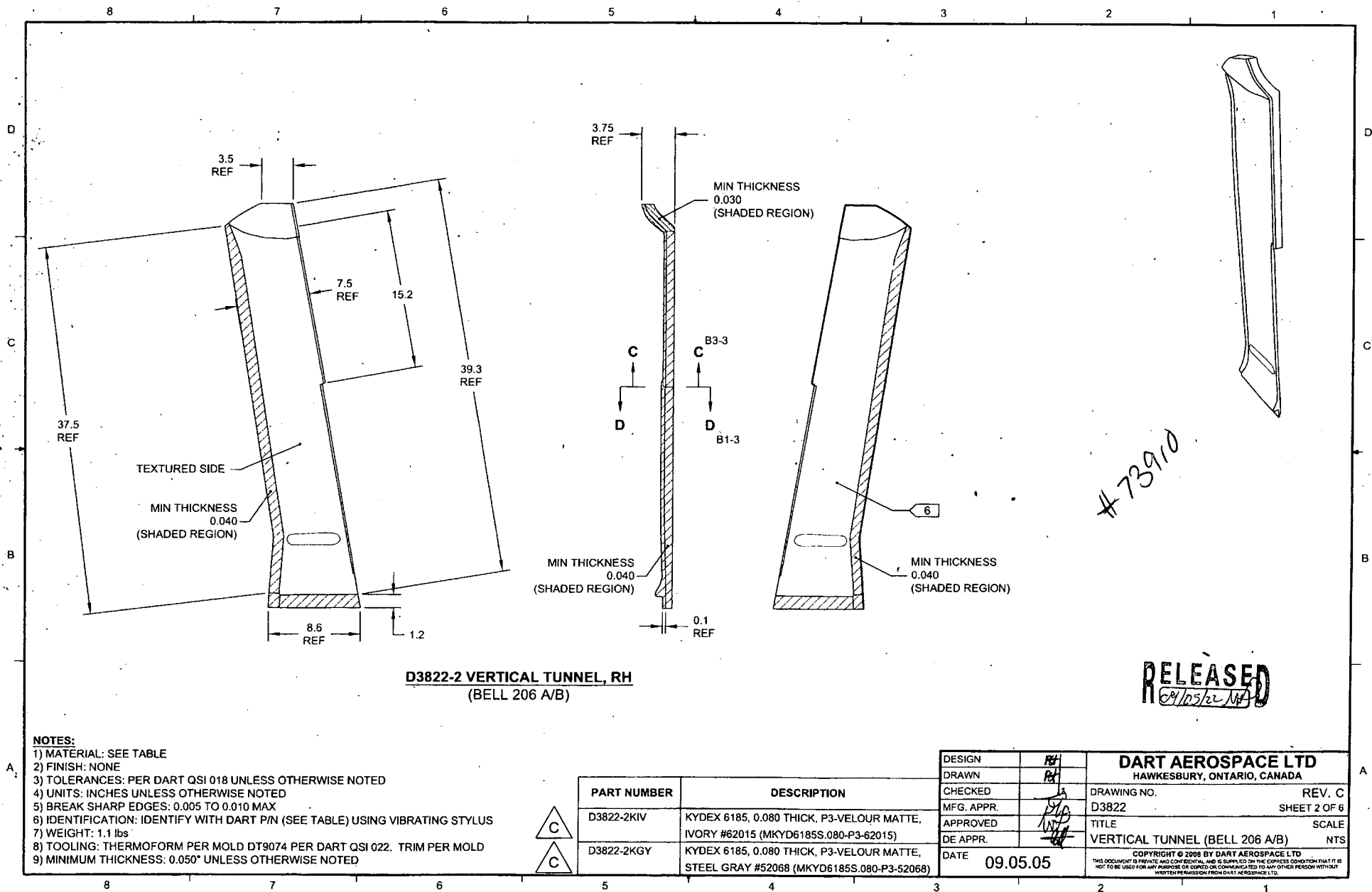
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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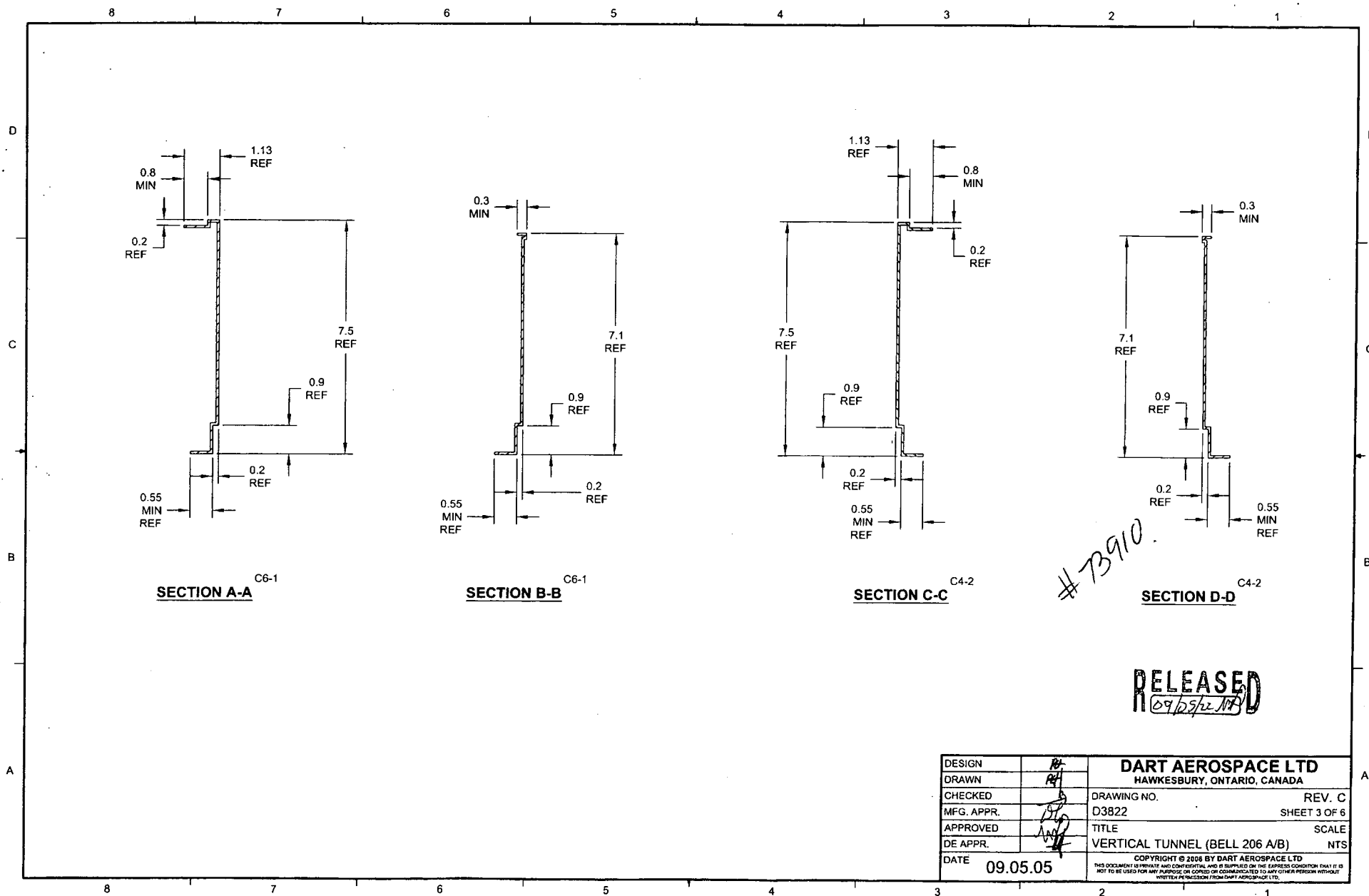
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



RELEASED  
09/05/12

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>RA</i>		
CHECKED	<i>RA</i>		
MFG. APPR.	<i>RA</i>		
APPROVED	<i>RA</i>		
DE APPR.	<i>RA</i>		
DATE	09.05.05	DRAWING NO. D3822	REV. C
		TITLE VERTICAL TUNNEL (BELL 206 A/B)	SHEET 3 OF 6
		SCALE NTS	
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

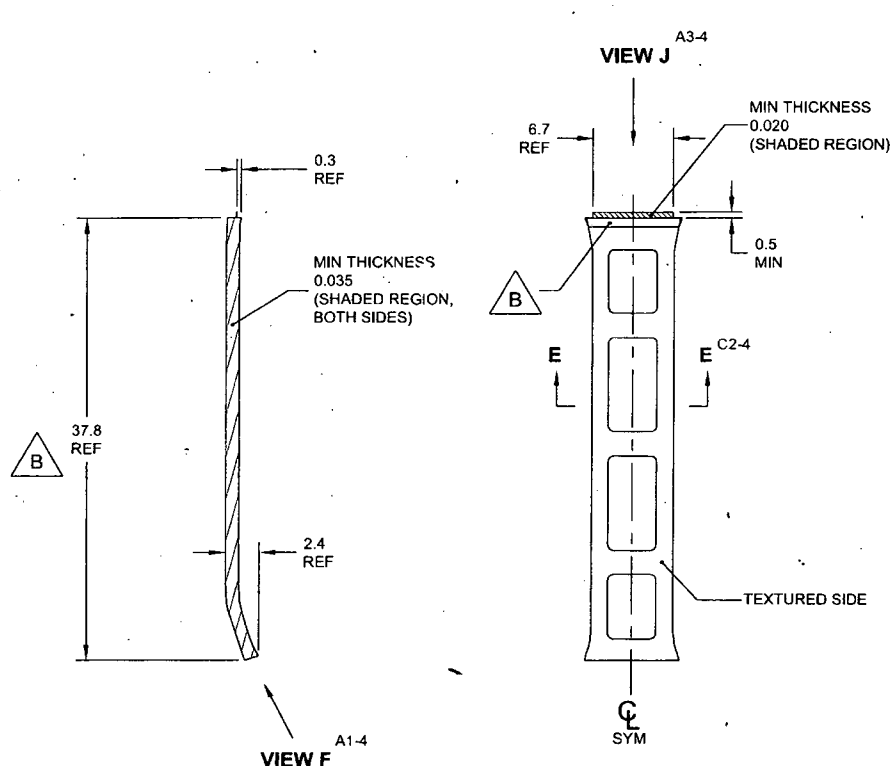


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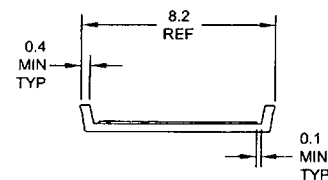
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C

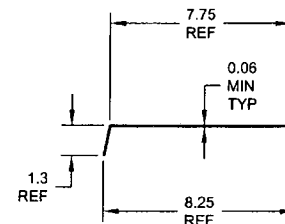
B



**D3822-3 VERTICAL TUNNEL, AFT CENTER**  
(BELL 206 A/B)



**VIEW J**  
SCALE 2X



**VIEW F**  
SCALE 2X  
(ROTATED 90° CW)

**RELEASED**  
9/65/22 M

**NOTES:**

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.1 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9072 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3822-3KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-3KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	RE	<b>DART AEROSPACE LTD</b>
DRAWN	RE	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. C
MFG. APPR.		D3822 SHEET 4 OF 6
APPROVED		TITLE SCALE
DE APPR.		VERTICAL TUNNEL (BELL 206 A/B) NTS
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8 7 6 5 4 3 2 1

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



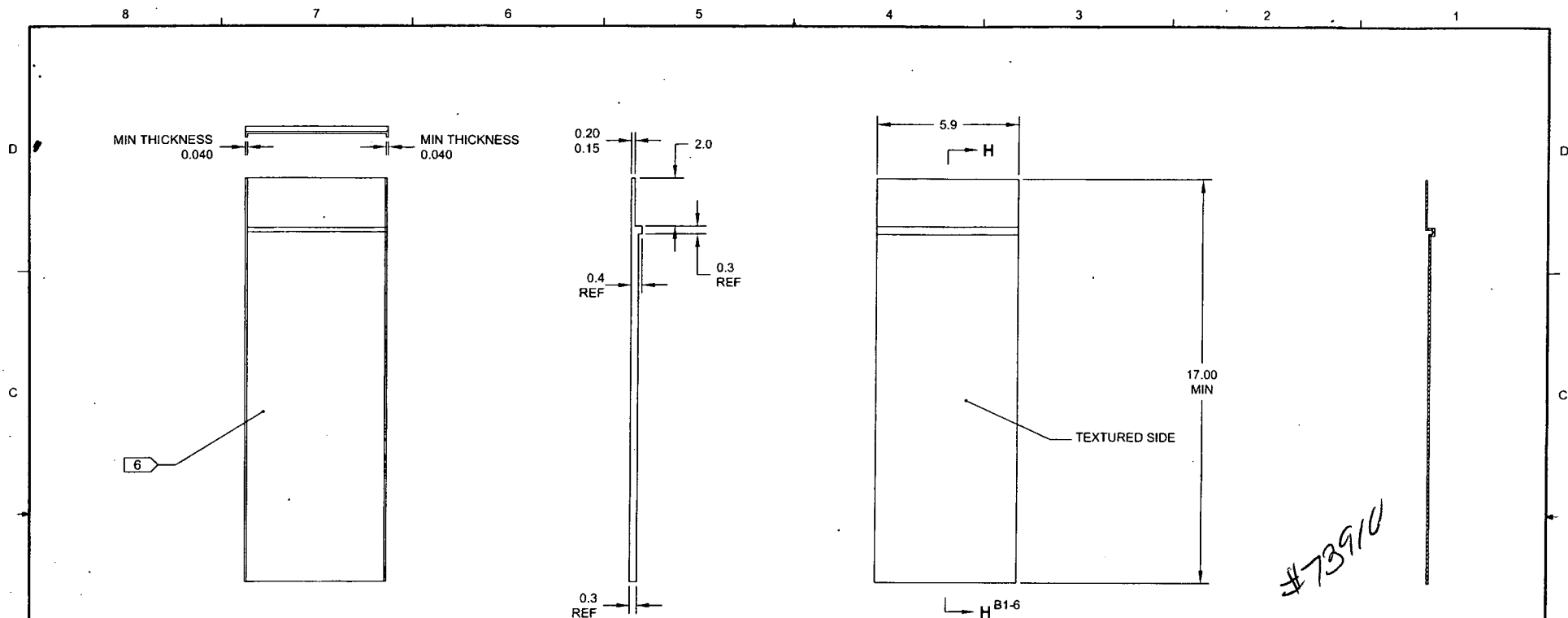
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**NOTE:** Date & initial all entries



**D3822-7 VERTICAL TUNNEL, LOWER**  
(BELL 206 A/B)

**SECTION H-H** B3-6

**NOTES:**

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) WITH VIBRATING STYLUS
- 7) WEIGHT: 0.36 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9396 PER DART QSI 022
- 9) MINIMUM THICKNESS: 0.060" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3822-7KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-7KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	PA	<b>DART AEROSPACE LTD</b>
DRAWN	PA	HAWKESBURY, ONTARIO, CANADA
CHECKED	PA	DRAWING NO. D3822
MFG. APPR.	PA	REV. C
APPROVED	PA	SHEET 6 OF 6
DE APPR.	PA	TITLE VERTICAL TUNNEL (BELL 206 A/B)
DATE	09.05.05	SCALE NTS
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order: 73910
Description: Vertical Tunnel, RH		Part Number: D3822-2KIV/KGY
Inspection Dwg: D3822	Rev: C	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>3/16</u> "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <u>Dh</u>	Date: <u>11/12/21</u>
------------------------	-----------------------

### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.8	Min	0.960"	✓		Visual DL-01	
0.3	Min	0.364"	✓		Visual DL-01	
0.55	Min	0.677"	✓		Visual DL-02	
0.040	Min	0.052"	✓		Visual DL-02	
0.050	Min	0.076"	✓		CAL TH-DT	

Measured by: <u>Dh</u>	Date: <u>11/12/22</u>
Audited by: <u>J</u>	Date: <u>11/17/23</u>
Prototype Approval: <u>N/A</u>	Date: <u>N/A</u>

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ <u>[Signature]</u>	<u>[Signature]</u>